

# Work Order ID 53401

November 03, 2009 3:21:59 PM

Page 1

Item ID: D350-607-043A Accept

Revision ID:

Item Name: Heli-Utility-Basket (Hydraulic Spring Upgrade)

Start Date: 11/4/2009 Start Qty: 1.00

Required Date: 11/11/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: mf Date: 09-11-03 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
DSI 9473	A

100 0.00



DOCUMENT CONTROL

DC

Memo

Document Control

Photocopy bluefile & type labels per PPPD350-607-043A CHG001

110 0.00



Pick Kit

Packaging

Memo

Packaging

120 0.00



Small Fab

Small Fab

Memo

Small Fab

Assemble as per Dwg D350-607  
Seal Support Gusset with Sikaflex -291  
Batch: M 112391  
Exp Date: 10/20

*Handwritten:* BG 09/11/12

*Handwritten:* 09/11/12 (1)

*Handwritten:* 10/11-12



*Handwritten:* PTO on pg 10 of pick list

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 53401**

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Page 2

Item ID: D350-607-043A

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Utility-Basket (Hydraulic Spring Upgrade)

Start Date: 11/4/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 11/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

1 9/11/12

140

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

9/11/11 Sel @ 12

150

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

MD 09/11/12

X1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Accept



Setup Start



Revision ID:

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Start Date: 11/4/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 11/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-607-043A

Location: *Druff**9/11/12**RSJ*POSITIVE  
RECALL

170

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

*09/11/12**MF 09-11-12*

POSITIVE RECALL

EFFECTIVE

AUTH

RELEASED

DATE

*09/11/12*

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Page 1

Work Order ID: 53401

Parent Item: D350-607-043A

Parent Item Name: Heli-Utility-Basket (Hydraulic Spring Upgrade)

Comments: IPP Rev A 09.11.03 new issue EC verified by:DD



Start Date: 11/4/2009

Required Date: 11/11/2009

Start Qty: 1.00



Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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AN310-4  NUT		Purchased	No			120	Each	84.0000	2.0000 			
---	--	-----------	----	--	--	-----	------	---------	---	--	--	--



9/11/11 SP

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	84	
	110098	34	
	112969	50	

AN3-16A  Bolt		Purchased	No			120	Each	89.0000	2.0000 			
--	--	-----------	----	--	--	-----	------	---------	---	--	--	--

2x50

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	89	
	111965	89	

AN3C11A  BOLT		Purchased	No			120	Each	100.0000	2.0000 			
--	--	-----------	----	--	--	-----	------	----------	---	--	--	--

2x50

9/11/11 SP

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	100	
	112255	50	
	112969	50	

2x50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 53401

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Comments: IPP Rev A 09.11.03 new issue EC verified by:DD

Start Date: 11/4/2009

Required Date: 11/11/2009

Start Qty: 1.00


Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C15A  Bolt		Purchased	No			120	Each	100.0000	2.0000			

9/11/09 SP

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	100	
112255	50	
112969	50	

2x50

AN4-13A  Bolt		Purchased	No			120	Each	289.0000	2.0000			
--	--	-----------	----	--	--	-----	------	----------	--------	--	--	--

9/11/09 SP

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	289	
107321	1	
107534	5	
107959	23	
109285	37	
110552	66	
110865	3	
111477	9	
111925	7	
112314	138	
17406	0	
51764	0	

2x50

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 53401

Parent Item: D350-607-043A

Parent Item Name: Heli-Utility-Basket (Hydraulic Spring Upgrade)

Comments: IPP Rev A 09.11.03 new issue EC verified by:DD



Start Date: 11/4/2009

Required Date: 11/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN4-22A		Purchased	No			120	Each	282.0000	5.0000			
												
Bolt												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

282

104937

8

107715



5

108483

69

111965

200

AN5-17A		Purchased	No			120	Each	92.0000	4.0000			
												
Bolt												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

92

102140

4

107939

2

110625

2

111965

4

112314

30

112385

50

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 53401

Parent Item: D350-607-043A

Parent Item Name: Heli-Utility-Basket (Hydraulic Spring Upgrade)


Comments: IPP Rev A 09.11.03 new issue EC verified by:DD

Start Date: 11/4/2009

Required Date: 11/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD416  Washer		Purchased	No			120	Each	4,501.000	14.0000			

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

4501

108161

519

110523

340

111279

101

111916

482

112314

3059

16941

0

9/11/11 sp

14x50

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 53401

Parent Item: D350-607-043A

Parent Item Name: Heli-Utility-Basket (Hydraulic Spring Upgrade)


Comments: IPP Rev A 09.11.03 new issue EC verified by:DD

Start Date: 11/4/2009

Required Date: 11/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD516  Washer		Purchased	No			120	Each	1,528.000	4.0000			

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

1528

100564

2

106167

6

107534

34

107959

43

108246

46

108672

2

109059

49

109752

22

110363

46

110523

57

111279

39

112082

68

112314

500

112794

114

112828

500

9/11/11 SP

4X SP

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Work Order ID: 53401

Parent Item: D350-607-043A

Parent Item Name: Heli-Utility-Basket (Hydraulic Spring Upgrade)


Comments: IPP Rev A 09.11.03 new issue EC verified by:DD

Start Date: 11/4/2009

Required Date: 11/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD8  Washer		Purchased	No			120	Each	1,427.000	2.0000		9/11/11 SP	

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

1427

107091

9

108335

11

110382

48

110917

3

111578

62

112314

500

112385

794

D2022-101RevN/A

Manufactured

No



Spacer

120

Each

560.0000

5.0000



2x SP

9/11/11 SP

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST504

560

45885

360

50746

100

52325

100

D2221RevH

Manufactured

No



350 Basket Base

120

Each

0.0000

1.0000



5x SP

BR 09-11-11

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 53401

Parent Item: D350-607-043A

Parent Item Name: Heli-Utility-Basket (Hydraulic Spring Upgrade)


Comments: IPP Rev A 09.11.03 new issue EC verified by:DD

Start Date: 11/4/2009

Required Date: 11/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2258-200RevC  Placard 200lb		Manufactured	No			120	Each	9.0000	1.0000		9/11/11	SP

Warehouse  
Location  
Main Warehouse

Loc Qty

Loc Code

ST 9  
48350 9

D2530RevB

Manufactured No



Handle Weldment

120 Each 10.0000 1.0000

Warehouse  
Location  
Main Warehouse

Loc Qty

Loc Code

ST 1  
51124 1

Main Warehouse

ST506 9  
52280 9

D2535RevA

Manufactured No



Spring

120 Each 48.0000 2.0000

Warehouse  
Location  
Main Warehouse

Loc Qty

Loc Code

ST 48  
46580 48

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W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Start Date: 11/4/2009

Required Date: 11/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2537RevA1  Bushing		Manufactured	No			120	Each	109.0000	2.0000			

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

109

52994

49

53181

60

9/11/11 SD

2x SD

22553 SP

9/11/11 SD

D2728-3RevB

Dart Logo label

D2931RevA

Bumper

Manufactured

No

120

Each

0.0000

2.0000

Manufactured

No

120

Each

955.0000

2.0000

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

955

46064

955

2x

BL 09-11-11

BL 09-11-11

D2989-041RevD

Basket Lid Assembly

D2989-043RevD

Basket Lid Assembly

Manufactured

No

120

Each

0.0000

1.0000

Manufactured

No

120

Each

0.0000

1.0000

B53404

B53407

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W/O:		WORK ORDER CHANGES					
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Comments: IPP Rev A 09.11.03 new issue EC verified by:DD


Start Date: 11/4/2009

Required Date: 11/11/2009

Start Qty: 1.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3953-11		Manufactured	No			120	Each	40.0000	1.0000			
												
Gas Spring Spacer												

Warehouse Loc Qty Loc Code

Location


Main Warehouse

ST139C

52767

40

40

D3953-15		Manufactured	No			120	Each	14.0000	1.0000			
												
Gas Spring Bracket												

Warehouse Loc Qty Loc Code

Location


Main Warehouse

ST

52762

14

14

D3953-17		Manufactured	No			120	Each	24.0000	1.0000			
												
Gas Spring Spacer												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

52763

24

24

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 53401

Parent Item: D350-607-043A

Parent Item Name: Heli-Utility-Basket (Hydraulic Spring Upgrade)









Comments: IPP Rev A 09.11.03 new issue EC verified by:DD

Start Date: 11/4/2009

Required Date: 11/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3953-3  Gas Spring Stud, Lid		Manufactured	No			120	Each	20.0000	1.0000 	9/16/17		
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST139B</div> <div>52757</div> <div>Loc Qty</div> <div>20</div> <div>20</div> <div>Loc Code</div>												
D3953-5  Gas Spring Stud, Base		Manufactured	No			120	Each	20.0000	2.0000 	1x 50		
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST139C</div> <div>52809</div> <div>Loc Qty</div> <div>20</div> <div>20</div> <div>Loc Code</div>												
D3953-9 <i>new Rev. B prelim.</i>  Gas Spring Washer		Manufactured	No			120	Each	40.0000	2.0000 	353434 sep 9/16/17		
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST139C</div> <div>52759</div> <div>Loc Qty</div> <div>40</div> <div>40</div> <div>Loc Code</div>												
D3969-1  Gas Spring (Basket Lid)		Manufactured	No			120	Each	0.0000	1.0000 	52809 9/16/17 sep		



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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-607-043A PAR #: \_\_\_\_\_ Fault Category: Eng chng. NCR: (Yes) No DQA: / Date: 05-12-14  
 Resolution: Documentation Revised Disposition: Other QA: N/C Closed: / Date: 05-12-14

NCR: <u>53401</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
05-11-11	120	The D3553-9 was found to be too thick and would not allow the cotter pin to pass through the bolt. Dwg Rev. A.  Rel. Eng chng.	<u>/</u> AS/UMZ	Prelim dwg Rev. B was made by Alan Stocker to have the washers made to 0.050" instead of 0.130".	<u>/</u> 05-11-11	<u>/</u> 05-11-11	<u>/</u> AS/UMZ	<u>/</u> 05-11-11
				Make new - 9 per Prelim Rev. B using Delvrim II M109103				
				Assemble per chng with Rev. B prelim washers.  Rev B released				

NOTE: Date & initial all entries

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Page 11

Work Order ID: 53401

Parent Item: D350-607-043A

Parent Item Name: Heli-Utility-Basket (Hydraulic Spring Upgrade)

Start Date: 11/4/2009

Required Date: 11/11/2009

Comments: IPP Rev A 09.11.03 new issue EC verified by:DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
k607-043RevCHG005 Pk Kit - D350-607-043		Manufactured	No			120	Each	0.0000	1.0000			
MS20600-AD4W3 Cherry Rivets		Purchased	No			120	Each	2,533.000	2.0000			

B 53418 / C 6/11/12 (1)

9/1/11 SP

2x50

9/1/11 SP

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

2533

102929

37

104715

10

106375

518

107939

1000

111636

968

MS21042L3

Purchased

No

120

Each

3,280.000

2.0000



Nut

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

3280

110844

32

111274

29

111668

719

112314

2000

112385

500

2x50

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 12

Work Order ID: 53401

Parent Item: D350-607-043A

Parent Item Name: Heli-Utility-Basket (Hydraulic Spring Upgrade)



Comments: IPP Rev A 09.11.03 new issue EC verified by:DD

Start Date: 11/4/2009

Required Date: 11/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L4  Nut		Purchased	No			120	Each	5,839.000	7.0000		9/11/11	SP

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

5839

110507

184

11182

5646

112314

9

15924

0

7xSP

MS21042L5



Nut

Purchased

No

120

Each

1,044.000

4.0000



9/11/11

SP

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

1044

110382

10

111127

4

111636

30

112314

1000

4xSP

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Page 12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 13

Work Order ID: 53401

Parent Item: D350-607-043A

Parent Item Name: Heli-Utility-Basket (Hydraulic Spring Upgrade)



Start Date: 11/4/2009

Required Date: 11/11/2009

Comments: IPP Rev A 09.11.03 new issue EC verified by:DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21043-3  Nut		Purchased	No			120	Each	5,023.000	4.0000		9/11/11	SP

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
OFFSHORE		
FG	80	
103691	80	
Main Warehouse		
ST	4943	
111819	78	
112243	39	
112314	4826	

MS24665-2-12

Purchased

No

120

Each

192.0000

2.0000



COTTER PIN

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	192	
111499	192	

NAS1149C0332

AN960C40L

Purchased

No

120

Each

0.0000

4.0000



Washer

NAS1149C0432H

AN960C416L

Purchased

No

120

Each

0.0000

2.0000



Washer

3x BK 09-11-12  
M112110 9/11/11 SP  
M112612 9/11/11 SP

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Page 13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Work Order ID: 53401

Parent Item: D350-607-043A

Parent Item Name: Heli-Utility-Basket (Hydraulic Spring Upgrade)


Comments: IPP Rev A 09.11.03 new issue EC verified by:DD

Start Date: 11/4/2009

Required Date: 11/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1515H4  Washer		Purchased	No			120	Each	194.0000	2.0000			

9/11/11 SP (K)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

194

111294

94

111525

100

2x

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Page 14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# DART SERVICE INSTRUCTION

TO AMEND DRAWING D350-607 REV. F OR SUBSEQUENT APPROVED REVISION

REF CANADIAN STC: SH94-14

FAA STC: SR00213NY

EASA STC: EASA.IM.R.S.01405

THE PURPOSE OF THIS DART SERVICE INSTRUCTION (DSI), IS TO PROVIDE OPERATORS OF AS350 / 355 ROTORCRAFT EQUIPPED WITH DART D350-607-041 HELI UTILITY BASKETS WITH AN UPGRADE KIT TO REPLACE THE EXISTING LID PROP ARM WITH 2 GAS SPRINGS.

FOR OPERATORS EQUIPPED WITH D350-607-043/-045/-047 HELI UTILITY BASKETS THIS DSI WILL PROVIDE AN UPGRADE KIT TO REPLACE THE EXISTING LID PROP ARM WITH 1 GAS SPRING.

ITEM No.	QTY -141	QTY -143	QTY -145	PART NUMBER	DESCRIPTION
1	X			D350-607-141	GAS SPRING KIT INSTALLATION (FOR USE ON -041 BASKET*)
2		X		D350-607-143	GAS SPRING KIT INSTALLATION (FOR USE ON -043/-047 BASKET*)
3			X	D350-607-145	GAS SPRING KIT INSTALLATION (FOR USE ON -045 BASKET*)
4	2		1	D3953-1	GAS SPRING BRACKET
5	2	1	1	D3953-3	GAS SPRING STUD (LID)
6	2	2	1	D3953-5	GAS SPRING STUD (BASE)
7	2		1	D3953-7	GAS SPRING SPACER
8	4	2	2	D3953-9	GAS SPRING WASHER
9	2	1	1	D3953-11	GAS SPRING SPACER
10	2		1	D3953-13	GAS SPRING SPACER
11		1		D3953-15	GAS SPRING BRACKET
12		1		D3953-17	GAS SPRING SPACER
13	2	1	1	D3969-1	GAS SPRING
14	4	2	2	AN3C11A	BOLT
15		2		AN3C15A	BOLT
18	4		2	AN3C16A	BOLT
19	4	2	2	AN310-4	CASTELLATED NUT
20	8	4	4	MS21043-3	NUT
21	4	2	2	MS24665-212	COTTER PIN
22	8	4	4	NAS1149C0332	WASHER
23	4	2	2	NAS1149C0432H	WASHER

**\*NOTE:** FOR CUSTOMERS WISHING TO ORDER NEW BASKETS WITH THE GAS SPRING KIT PRE-INSTALLED USE THE FOLLOWING NUMBERS:

D350-607-041 BASKET WITH GAS SPRING UPGRADE KIT = D350-607-041A

D350-607-043 BASKET WITH GAS SPRING UPGRADE KIT = D350-607-043A




D350-607-045 BASKET WITH GAS SPRING UPGRADE KIT = D350-607-045A

D350-607-047 BASKET WITH GAS SPRING UPGRADE KIT = D350-607-047A

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED  
BY:   
D. SHEPHERD (DE # 02)

DATE: 09.09.15  
CERT. NO.: SH94-14  
ISSUE NO.: 4

A	NEW ISSUE	AJS	09.09.15
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. REV. A DSI 9473 SHEET 1 OF 8 TITLE SCALE GAS SPRING UPGRADE KIT NTS	
DRAWN	AJS		
CHECKED			
MFG. APPR.	N/A		
APPROVED			
DE APPR.			
DATE	09.09.15	COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

FOR D350-607-041 BASKETS, REPLACE THE EXISTING D2332-041 PROP ARM ASSEMBLY AS FOLLOWS:

### **D350-607-141 GAS SPRING KIT INSTALLATION**

**NOTE:** ONCE THIS MODIFICATION IS COMPLETE YOU WILL NOT BE ABLE TO RE-INSTALL THE D2332-041 PROP ARM.

- 1) REMOVE THE D2332-041 PROP ARM.
  - 2) GRIND FLUSH THE D2327-3 SPACER BUSHING ON BOTH ENDS OF THE BASKET AS SHOWN IN FIGURE 1 (IT IS PERMISSIBLE TO GRIND ALL 4 SPACERS FLUSH). TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4.
  - 3) LOCATE THE D3953-1 GAS SPRING BRACKET AS SHOWN IN FIGURE 1. TRIM STEEL MESH LOCALLY AS REQUIRED. TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4. TRANSFER MARK AND DRILL 2X Ø0.194 HOLES THRU THE BASKET LID SQUARE TUBE STRUCTURE AS SHOWN IN DETAIL A. INSTALL THE D3953-1 GAS SPRING BRACKET & D3953-13 GAS SPRING SPACER USING 2X AN3C16A BOLT, 2X NAS1149C0332 WASHER & 2X MS21043-3 NUT AS SHOWN IN VIEW E-E.
  - 4) LOCATE THE D3953-5 GAS SPRING STUD AS SHOWN IN FIGURE 1. TRIM STEEL MESH LOCALLY AS REQUIRED. TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4. TRANSFER MARK AND DRILL 2X Ø0.194 HOLES THRU THE BASKET BASE SQUARE TUBE STRUCTURE AS SHOWN IN DETAIL B. FASTEN D3953-5 IAW VIEW F-F USING 2X AN3C11A BOLT, 2X NAS1149C0332 WASHER & 2X MS21043-3 NUT.
  - 5) INSTALL 1X D3953-11 GAS SPRING SPACER ONTO THE D3953-5 STUD AS SHOWN IN VIEW F-F. INSTALL THE LARGE END OF THE D3969-1 GAS SPRING SPRING ONTO THE D3953-5 GAS SPRING STUD AND FASTEN IN PLACE USING 1X D3953-9 GAS SPRING WASHER, 1X NAS1149C0432H WASHER, 1X AN310-4 CASTELATTED NUT & 1X MS24665-212 COTTER PIN AS SHOWN IN VIEW F-F. INSTALL COTTER PIN PER MS33540 OR AC43.13 CHAPTER 7-127.
  - 6) INSERT THE D3953-3 GAS SPRING STUD INTO THE D3953-1 GAS SPRING BRACKET & INSERT THE D3953-7 GAS SPRING SPACER ONTO THE D3953-3 GAS SPRING AS SHOWN IN VIEW E-E. RAISE THE BASKET LID AND INSTALL THE ROD END OF THE D3969-1 GAS SPRING ONTO THE D3953-3 GAS SPRING STUD USING 1X D3953-9 GAS SPRING WASHER, 1X NAS1149C0432H WASHER, 1X AN310-4 CASTELATTED NUT & 1X MS24665-212 COTTER PIN AS SHOWN IN VIEW E-E. INSTALL COTTER PIN PER MS33540 OR AC43.13 CHAPTER 7-127.
- NOTE:** THE D3953-3 GAS SPRING STUD CAN BE HELD IN PLACE WITH A  $\frac{9}{16}$  OPEN END SPANNER / WRENCH.

**NOTE:** WITH THE LID IN THE CLOSED POSITION THE GAS SPRING SHOULD NOT BE FULLY COMPRESSED.

7) REPEAT STEPS 2 THROUGH 6 AT THE OTHER END OF THE BASKET.

8) TEST THE INSTALLATION. IF INSTALLED PROPERLY THE GAS SPRINGS SHOULD ASSIST THE BASKET USER IN BOTH OPENING AND CLOSING THE BASKET LID.

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY: *[Signature]*  
D. SHEPHERD (DE # 02)

DATE: 09.09.15

CERT. NO.: SH94-14

ISSUE NO.: 4

#550201

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9473	SHEET 2 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	GAS SPRING UPGRADE KIT	NTS
DATE	09.09.15	COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

FOR D350-607-043/-047 BASKETS REPLACE THE EXISTING D2332-041 PROP ARM ASSEMBLY AS FOLLOWS:

### **D350-607-143 GAS SPRING KIT INSTALLATION**

**NOTE:** THIS KIT MAY BE INSTALLED AT EITHER END OF THE BASKET. HOWEVER, THE PROP ARM MUST BE REMOVED IN EITHER CASE AS IT WILL INTERFERE WITH THE FUNCTION OF THE GAS SPRING.

- 1) REMOVE THE D2332-041 PROP ARM.
- 2) GRIND FLUSH THE D2327-3 SPACER BUSHING ON THE END OF THE BASKET WHERE THE GAS SPRING KIT IS BE INSTALLED AS SHOWN IN FIGURE 2 (IT IS PERMISSIBLE TO GRIND ALL 4 SPACERS FLUSH). TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4.
- 3) LOCATE THE D3953-15 GAS SPRING BRACKET AS SHOWN IN FIGURE 2. TRIM STEEL MESH LOCALLY AS REQUIRED. TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4. TRANSFER MARK AND DRILL 2X Ø0.194 HOLES THRU THE BASKET LID SQUARE TUBE STRUCTURE AS SHOWN IN DETAIL C. INSTALL THE D3953-15 GAS SPRING BRACKET & D3953-17 GAS SPRING SPACER USING 2X AN3C15A BOLT, 2X NAS1149C0332 WASHER & 2X MS21043-3 NUT AS SHOWN IN VIEW G-G.
- 4) LOCATE THE D3953-5 GAS SPRING STUD AS SHOWN IN FIGURE 2. TRIM STEEL MESH LOCALLY AS REQUIRED. TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4. TRANSFER MARK AND DRILL 2X Ø0.194 HOLES THRU THE BASKET BASE SQUARE TUBE STRUCTURE AS SHOWN IN DETAIL D. INSTALL 2X AN3C11A BOLT, 2X NAS1149C0332 WASHER & 2X MS21043-3 NUT AS SHOWN IN VIEW H-H. INSTALL THE ROD END OF THE D3969-1 GAS SPRING ONTO THE D3953-3 GAS SPRING STUD USING 1X D3953-9 GAS SPRING WASHER, 1X NAS1149C0432H WASHER, 1X AN310-4 CASTELATTED NUT & 1X MS24665-212 COTTER PIN AS SHOWN IN VIEW H-H. INSTALL COTTER PIN PER MS33540 OR AC43.13 CHAPTER 7-127 .
- 5) INSERT THE D3953-3 GAS SPRING STUD INTO THE D3953-15 GAS SPRING BRACKET & INSERT THE D3953-7 GAS SPRING SPACER ONTO THE D3953-3 GAS SPRING STUD AS SHOWN IN VIEW G-G. RAISE THE BASKET LID AND INSTALL THE D3969-1 GAS SPRING ONTO THE D3953-3 GAS SPRING STUD AND FASTEN IN PLACE USING 1X D3953-9 GAS SPRING WASHER, 1X NAS1149C0432H WASHER, 1X AN310-4 CASTELATTED NUT & 1X MS24665-212 COTTER PIN AS SHOWN IN VIEW G-G. INSTALL COTTER PIN PER MS33540 OR AC43.13 CHAPTER 7-127.

**NOTE:** THE D3953-3 GAS SPRING STUD CAN BE HELD IN PLACE WITH A  $\frac{9}{16}$  OPEN END SPANNER / WRENCH.

**NOTE:** WITH THE LID IN THE CLOSED POSITION THE GAS SPRING SHOULD NOT BE FULLY COMPRESSED.

- 6) TEST THE INSTALLATION. IF INSTALLED PROPERLY THE GAS SPRING SHOULD ASSIST THE BASKET USER IN BOTH OPENING AND CLOSING THE BASKET LID.

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY: [Signature]  
D. SHEPHERD (DE # 02)

DATE: 09.09.15  
CERT. NO.: SH94-14  
ISSUE NO.: 4

\*53401

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<u>[Signature]</u>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9473	SHEET 3 OF 8
APPROVED	<u>[Signature]</u>	TITLE	SCALE
DE APPR.	<u>[Signature]</u>	GAS SPRING UPGRADE KIT	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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FOR D350-607-045 BASKETS REPLACE THE EXISTING D2332-041 PROP ARM ASSEMBLY AS FOLLOWS:

### **D350-607-145 GAS SPRING KIT INSTALLATION**

**NOTE:** THIS KIT MAY BE INSTALLED AT EITHER END OF THE BASKET. HOWEVER, THE PROP ARM MUST BE REMOVED IN EITHER CASE AS IT WILL INTERFERE WITH THE FUNCTION OF THE GAS SPRING.

- 1) REMOVE THE D2332-041 PROP ARM.
  - 2) GRIND FLUSH THE D2327-3 SPACER BUSHING ON THE END OF THE BASKET WHERE THE GAS SPRING KIT IS BE INSTALLED AS SHOWN IN FIGURE 1 (IT IS PERMISSIBLE TO GRIND ALL 4 SPACERS FLUSH). TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4.
  - 3) LOCATE THE D3953-1 GAS SPRING BRACKET AS SHOWN IN FIGURE 1. TRIM STEEL MESH LOCALLY AS REQUIRED. TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4. TRANSFER MARK AND DRILL 2X Ø0.194 HOLES THRU THE BASKET LID SQUARE TUBE STRUCTURE AS SHOWN IN DETAIL A. INSTALL THE D3953-1 GAS SPRING BRACKET & D3953-13 GAS SPRING SPACER USING 2X AN3C16A BOLT, 2X NAS1149C0332 WASHER & 2X MS21043-3 NUT AS SHOWN IN VIEW E-E.
  - 4) LOCATE THE D3953-5 GAS SPRING STUD AS SHOWN IN FIGURE 1. TRIM STEEL MESH LOCALLY AS REQUIRED. TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4. TRANSFER MARK AND DRILL 2X Ø0.194 HOLES THRU THE BASKET BASE SQUARE TUBE STRUCTURE AS SHOWN IN DETAIL B. FASTEN D3953-5 IAW VIEW F-F USING 2X AN3C11A BOLT, 2X NAS1149C0332 WASHER & 2X MS21043-3 NUT.
  - 5) INSTALL 1X D3953-11 GAS SPRING SPACER ONTO THE D3953-5 STUD AS SHOWN IN VIEW F-F. INSTALL THE LARGE END OF THE D3969-1 GAS SPRING SPRING ONTO THE D3953-5 GAS SPRING STUD AND FASTEN IN PLACE USING 1X D3953-9 GAS SPRING WASHER, 1X NAS1149C0432H WASHER, 1X AN310-4 CASTELATTED NUT & 1X MS24665-212 COTTER PIN AS SHOWN IN VIEW F-F. INSTALL COTTER PIN PER MS33540 OR AC43.13 CHAPTER 7-127.
  - 6) INSERT THE D3953-3 GAS SPRING STUD INTO THE D3953-1 GAS SPRING BRACKET & INSERT THE D3953-7 GAS SPRING SPACER ONTO THE D3953-3 GAS SPRING AS SHOWN IN VIEW E-E. RAISE THE BASKET LID AND INSTALL THE ROD END OF THE D3969-1 GAS SPRING ONTO THE D3953-3 GAS SPRING STUD USING 1X D3953-9 GAS SPRING WASHER, 1X NAS1149C0432H WASHER, 1X AN310-4 CASTELATTED NUT & 1X MS24665-212 COTTER PIN AS SHOWN IN VIEW E-E. INSTALL COTTER PIN PER MS33540 OR AC43.13 CHAPTER 7-127.
- NOTE:** THE D3953-3 GAS SPRING STUD CAN BE HELD IN PLACE WITH A  $\frac{9}{16}$  OPEN END SPANNER / WRENCH.

**NOTE:** WITH THE LID IN THE CLOSED POSITION THE GAS SPRING SHOULD NOT BE FULLY COMPRESSED:

- 7) TEST THE INSTALLATION. IF INSTALLED PROPERLY THE GAS SPRING SHOULD ASSIST THE BASKET USER IN BOTH OPENING AND CLOSING THE BASKET LID.

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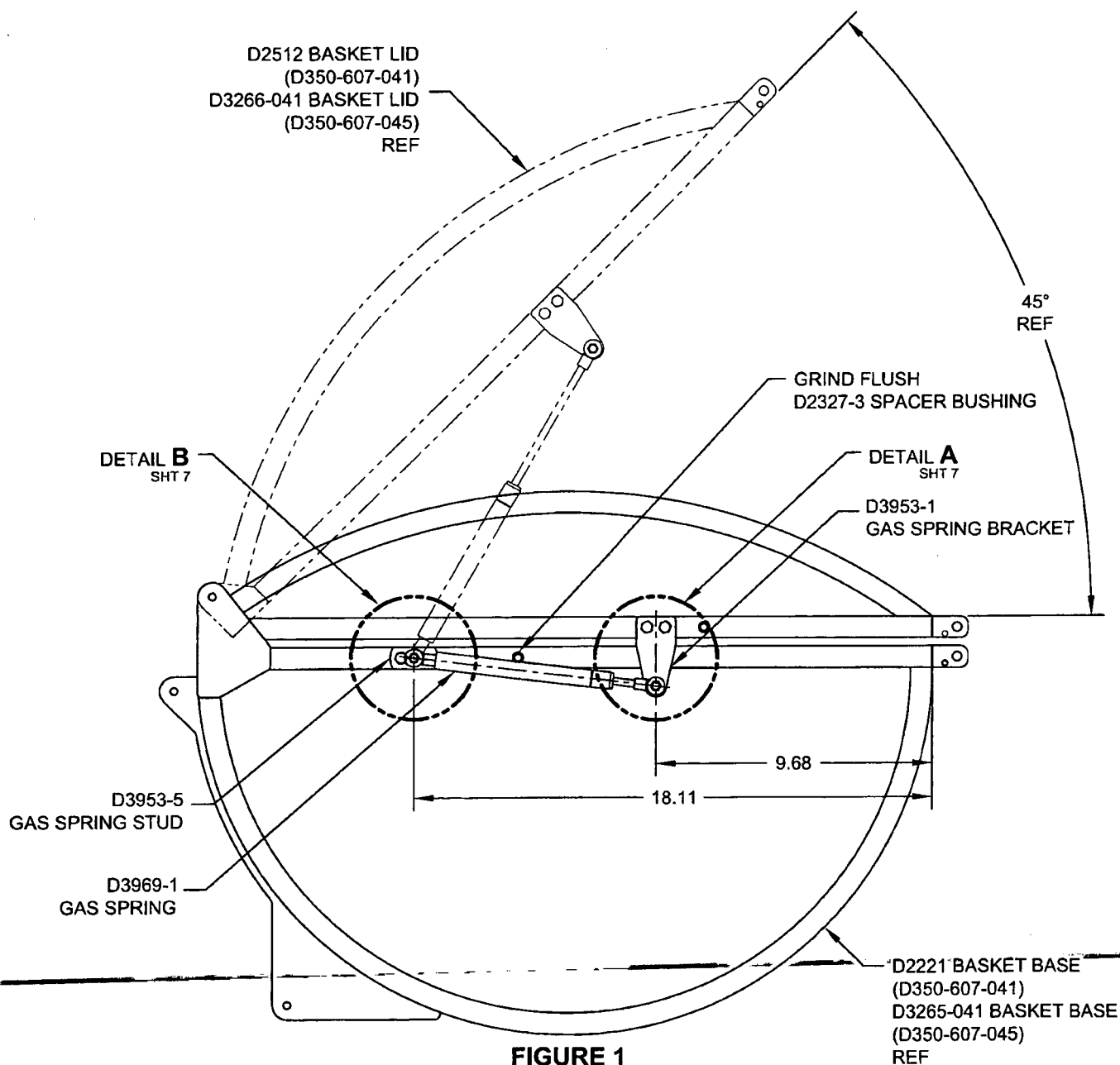
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**FIGURE 1**

**D350-607-141 GAS SPRING KIT INSTALLATION**

(BOTH ENDS)

**D350-607-145 GAS SPRING KIT INSTALLATION**

(1 END ONLY)

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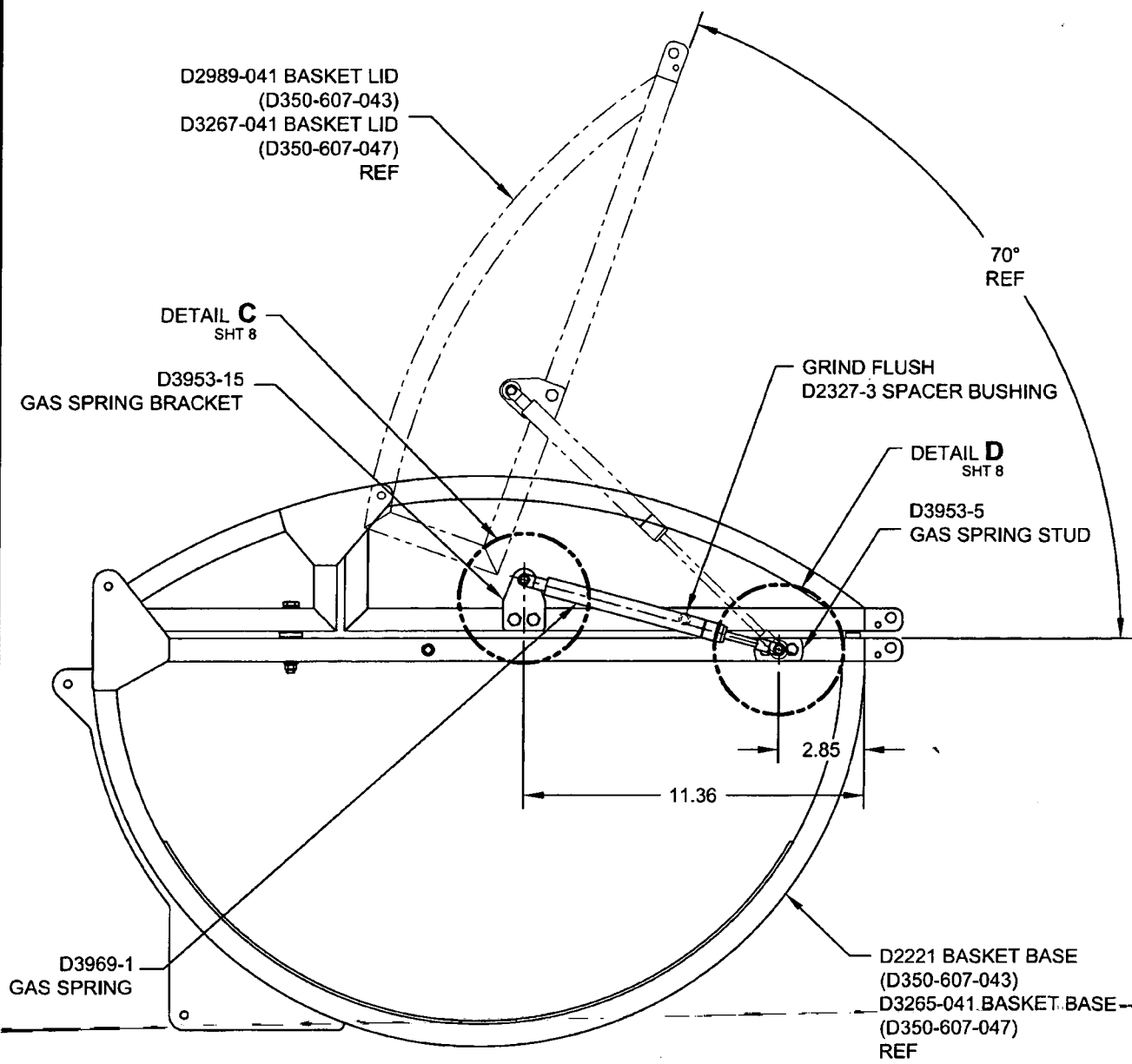
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**FIGURE 2**  
**D350-607-143 GAS SPRING KIT INSTALLATION**  
 (1 END ONLY)

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AN3C15A BOLT  
NAS1149C0332 WASHER  
MS21043-3 NUT  
2 PL

D3953-17  
GAS SPRING SPACER  
D3953-15  
GAS SPRING BRACKET  
REF  
D3953-7  
GAS SPRING SPACER  
D3953-9  
GAS SPRING WASHER

D3953-3 GAS SPRING STUD  
AN310-4 CASTELLATED NUT  
MS24665-212 COTTER PIN  
NAS1149C0432 WASHER

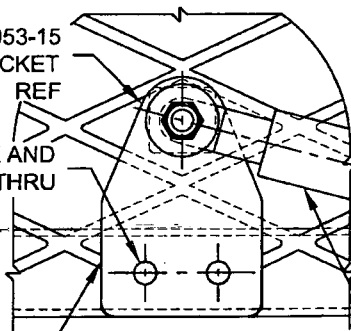
**VIEW G-G**



D3953-15  
GAS SPRING BRACKET  
REF  
TRANSFER MARK AND  
DRILL Ø0.194 THRU

TRIM MESH LOCALLY  
AS REQUIRED

**DETAIL C**



D3969-1  
GAS SPRING  
REF

AN3C11A BOLT  
NAS1149C0332 WASHER  
MS21043-3 NUT  
2 PL

D3953-5  
GAS SPRING STUD  
REF  
D3953-11  
GAS SPRING SPACER  
D3953-9  
GAS SPRING WASHER

AN310-4 CASTELLATED NUT  
MS24665-212 COTTER PIN  
NAS1149C0432 WASHER

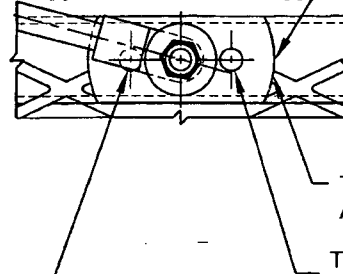
**VIEW H-H**



D3953-5  
GAS SPRING STUD  
REF

TRIM MESH LOCALLY  
AS REQUIRED  
TRANSFER MARK AND  
DRILL Ø0.194 THRU

**DETAIL D**



D3969-1  
GAS SPRING  
REF




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